

Work Order ID 145363-2 *Split-2-* *145363*

Thursday, May 05, 2016 3:18:23 PM

Page 1

Item ID: D2230-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 5/20/2016 Start Qty: 80.00 *80* 40X
 Required Date: 6/1/2016 Req'd Qty: 80.00 *80*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: *sem* Date: *10/05/05* Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								
110	Outsource process - Machining	0.00							DAS
110	HAAS CNC VERTICAL MACHINING #1								13
Outsource5	Memo	0.00							9-89
Outsource process - Machining	Issue P/O to Metec : <i>32323</i>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	1.60							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							DAS
130									38
QC	Memo	0.00							9-89
Quality Control									

80 MAY 10 2016

40X *Sp/6-6-1*

(40) *38* *9-89*

JUN 27 2016

Page 2

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140 HandFinish Hand Finishing	Memo	0.00							
150	QC7-Inspect Chemical Conversion Coat	0.00							
150 QC Quality Control	Memo	0.80							
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160 Powdercoat Powder Coating	Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00							

Picklist Print

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Page 1

Work Order ID: 145363

145363

Parent Item: D2230-3

D2230-3

Parent Item Name: Mounting Lug

Start Date: 5/20/2016

Required Date: 6/1/2016

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder coat EC
25 JLM VERIFIED BY: EC
IPP REV : E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		80			
D2230-3P									**				
Lug													
D2423		Manufactured	No				f	272.8334		5.751579			
D2423									**				
Lug Extrusion													

40x 80/6-6-1

MAY 10 2016

Location

Metec

Loc Qty

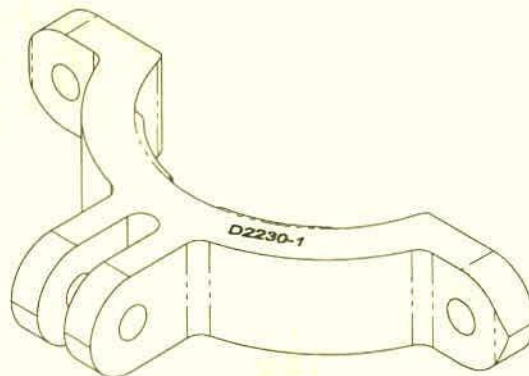
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38.9964647

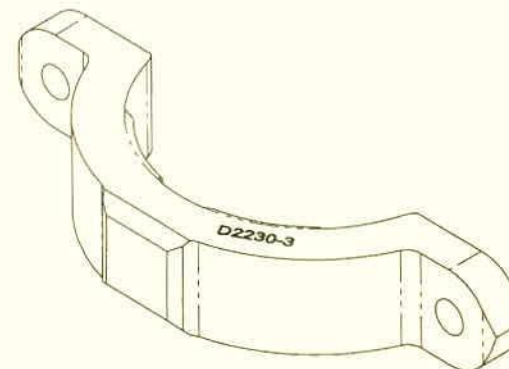
233.836981

Loc Code

DAS
13
9-22



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/06/15



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs.

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

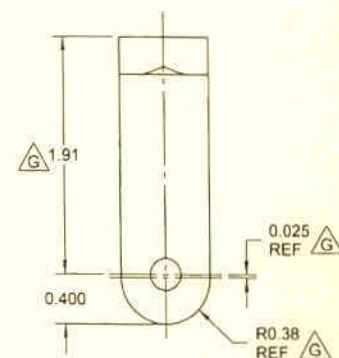
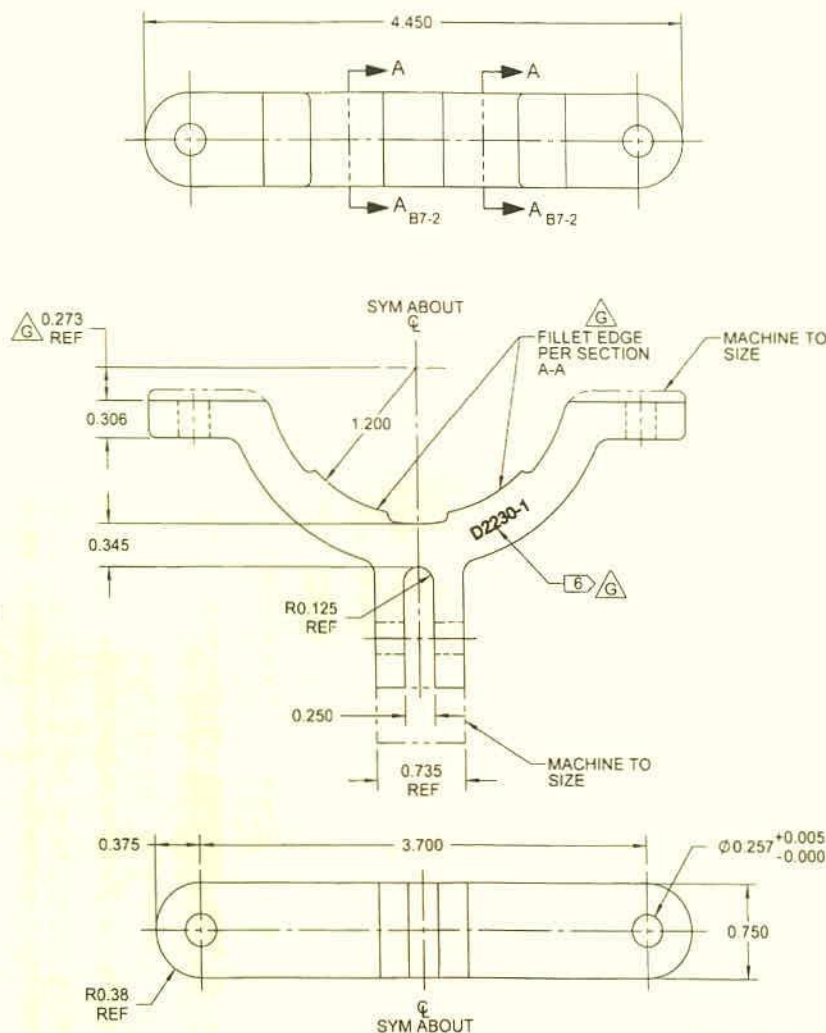
w/o 145363

Em 16/05/05

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

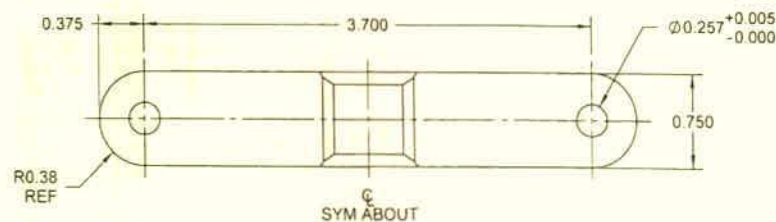
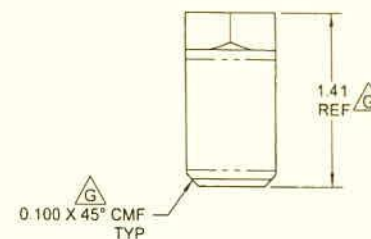
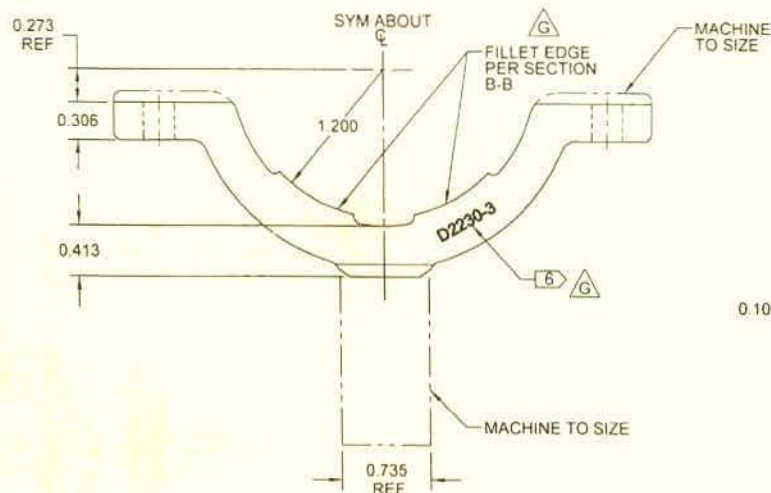
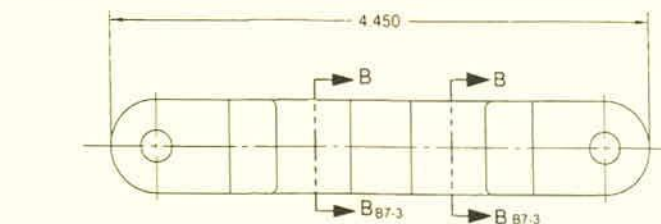
RELEASED
09/06/15

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG APPR		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
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SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
9/26/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678 3957
Fax: (613) 678-3956

Delivery Slip No.: 21245
Date: May 18, 2016
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 32323	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: May 18, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, as per drawing D2230 Rev.G Alodine and Paint as per QSI 005	Each	100 1	50	
D2230-3 Mounting Lug, as per drawing D2230 Rev.G Alodine and Paint as per QSI 005	Each	80 1	40	
Sp/6-6-1				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32323

Purchase Order Date 5/10/2016

PO Print Date 5/10/2016

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

MAY 10 2016

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D2230-1P	Lug	5/20/2016 Yes 5/20/2016		100.00 Each	\$16.10	\$1,610.00

AS PER DWG D2230 REV. G
B145246
ALODINE AND PAINT AS PER QSI 005

Line Total: \$1,610.00

2	D2230-3P	Lug	5/20/2016 Yes 5/20/2016	FN	80.00 Each	\$13.80	\$1,104.00
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AS PER DWG D2230 REV. G
B145363
ALODINE AND PAINT AS PER QSI 005

Line Total: \$1,104.00

Note:

5/10/2016



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2230-1	Lug Paint Batch# 20393	32323
40	D2230-3	Lug Paint Batch# 20393	32323

MATERIAL: supplied by DART B131451

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, May 18, 2016